

Date: Thursday, 07/02/2008 2:55:19 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : STEP BRACKET

Job Number : 37298

Estimate Number : 13161

P.O. Number :

This Issue : 07/02/2008 S.O. No. :

Prsht Rev. : NC

First Issue : // Type : SMALL / MED FAB

Previous Run :

Written By : WChecked & Approved By : W

Comment : Est Rev:A 08-01-30 new issue DD verified by:EC

Part Number : D37291

Drawing Number : D3729 U/R

Project Number : N/A

Drawing Revision : U/R

Material :

Due Date : 08/02/2008

POSITIVE
RECALL

Qty: 6 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X05000 6061-T6 Bar .50" x 5.0"



M6061T6B0500X06000 mic 2008/02

Comment: Qty.: 1.0062 f(s)/Unit Total : 6.0373 f(s)

6061T6 aluminium bar 5.00" X .50" thick

(M6061T6B0500X05000)

Batch: 106858 IB 8-2-8

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3729

Dwg Rev: U/R IB 8-2-8Prog Rev: U/R

2- Deburr if necessary IB 8-2-8

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr if necessary

SAD 08:02:08 (6)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 07/02/2008 2:55:19 PM
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Drawing Name: STEP BRACKET

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING
APPROVAL

08.02.11

6

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08.02.12

6

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 08-02-12

6

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: W/H

08.02.12

6

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/02/12

6

Job Completion



2008/2/12

6

U

POSITIVE RECALL

EFFECTIVE 08.02.07 AUTH

RELEASED 08.02.11 DATE

SCRAPPED
Qty 5
W/O 37582

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

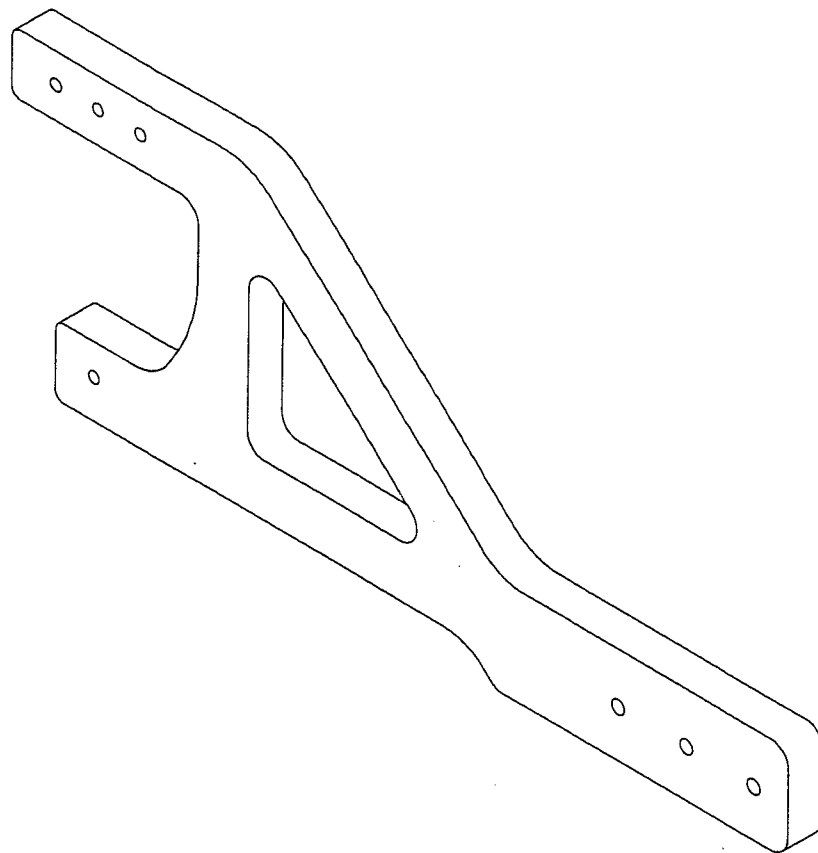
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Prog done
Est done

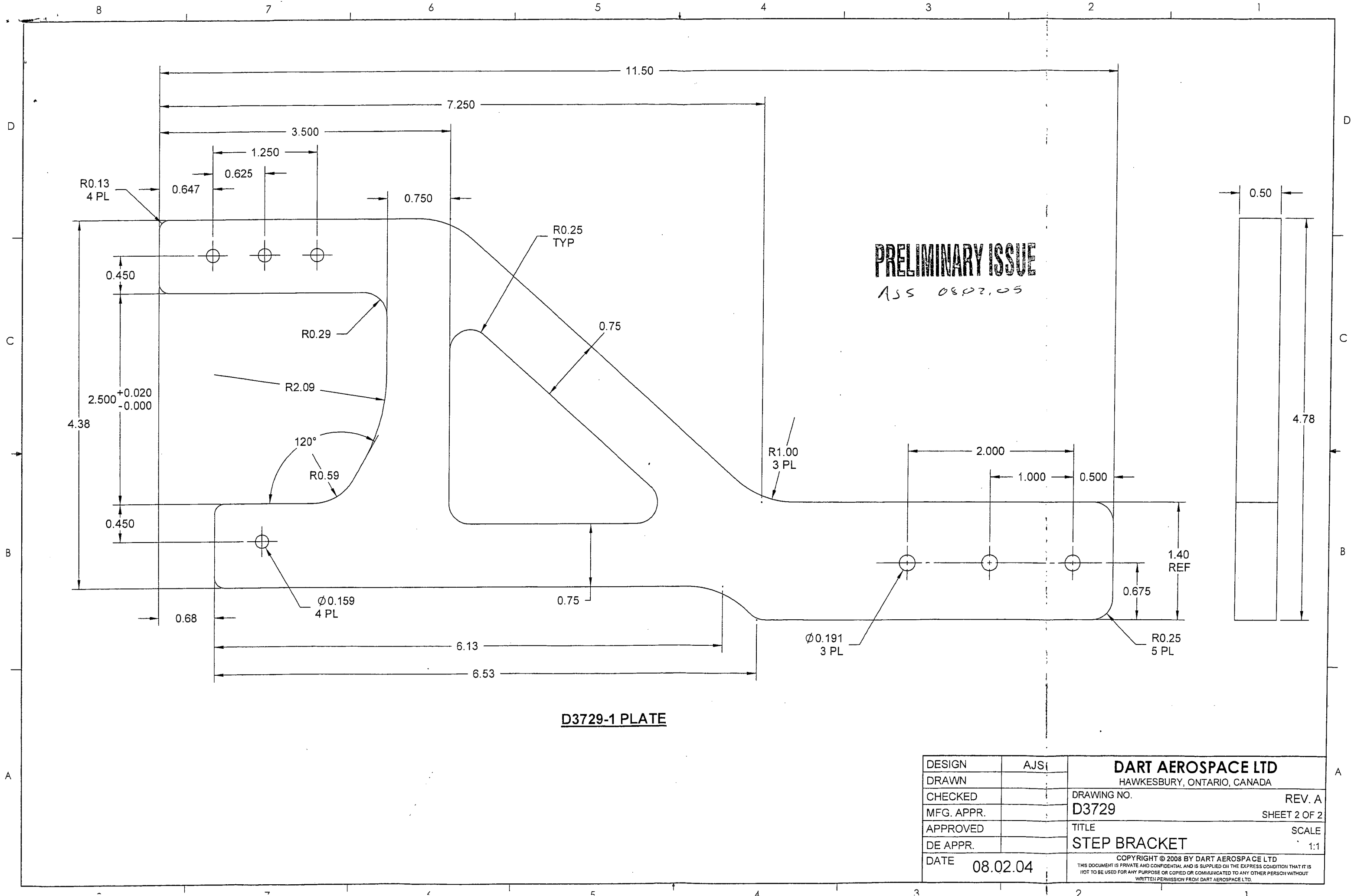


PRELIMINARY ISSUE
AJS 08.02.05

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.500 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.500)
OR: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF DART SPEC M6061T6B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.00 lbs

A	NEW ISSUE	AJS	08.02.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3729	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STEP BRACKET	NTS
DATE	08.02.04	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3729-1 PLATE

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3729	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STEP BRACKET	1:1
DATE	08.02.04	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE LTD		Work Order:	37298
Description: STEP BRACKET		Part Number:	D3729-1
Inspection Dwg: D3729-1 Rev: U/R		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .159	+ .005 - .001	.164	X			
Ø .41	+ .005 - .001	.196	X			
4.38	+/- .030	4.386	X			
11.50	+/- .030	11.50	✓			
.450	+/- .010	.450	✓			
.647	+/- .010	.645	✓			
.625	+/- .010	.628	✓			
1.250	+/- .010	1.250	✓			
.750	+/- .010	.755	✓			
2.500	+/- .010	2.492	X			
.450	+/- .010	.450	✓			
.75	+/- .030	.755	✓			
3.500	+/- .010	3.495	✓			
6.53	+/- .030	6.53	✓			
7.250	+/- .010	7.250	✓			
2.000	+/- .010	2.000	✓			
1.000	+/- .010	1.000	✓			
.500	+/- .010	.500	✓			
.675	+/- .010	.675	✓			
1.40	+/- .030	1.403	✓			

Measured by: B	Audited by: [Signature]	Prototype Approval: [Signature]
Date: 8-2-8	Date: 08/02/08	Date: 08.02.11

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	